

Work Order ID 50483

July 10, 2009 2:33:43 PM

PROTOTYPE



Page 1

Item ID: D3830-2KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Vertical Tunnel Upper, RH

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-10 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3830

A-PROTO 09.06.12

100

0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB 09/07/15 (X1)
M109723

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA055 using tool DT9319
Dwg Rev: A
Folio Rev: A

BB 09/07/15 (X1)

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Page 2

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Required Date: 07/17/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Hand Thermoforming

0.00

Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

BB 09/07/15 (X1)

DL 09/07/15 (X1)

DL 09/07/15 (X1)

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Page 3

Item ID: D3830-2KIV

Accept

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Item Name: Vertical Tunnel Upper, RH

Start Date: 07/13/2009 Start Qty: 1.00

Required Date: 07/17/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

Complete FAI document

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

Sh 09/07/15 (81)

RE 09-07-20 ENGINEERING APPROVAL

FOR ENG'G TEST
RE 09-07-20

Work Order ID 50483

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Item ID: D3830-2KIV

Accept



Setup Start



Revision ID: A-PROTO

Item Name: Vertical Tunnel Upper, RH

Stop



Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

A.09.07.20 prototype

Quality Control

P. 24-07-09

Picklist Print

July 10, 2009 2:33:42 PM

Page 1

Work Order ID: 50483

Parent Item: D3830-2KIVRevA-PROTO

Parent Item Name: Vertical Tunnel Upper, RH

Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	894.5038	1.5000			



6185 KYDEX .080"



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

894.5037653

109703

894.503765

M 109703.

26" x 21" ÷ 2

SEE W/O 50482

DART AEROSPACE LTD	Work Order: 50483
Description:	Part Number: D3830-2K ✓
Inspection Dwg: D3830 2 Rev: A PROTO	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>BB</u>	Date: <u>09/07/16</u>
------------------------	-----------------------

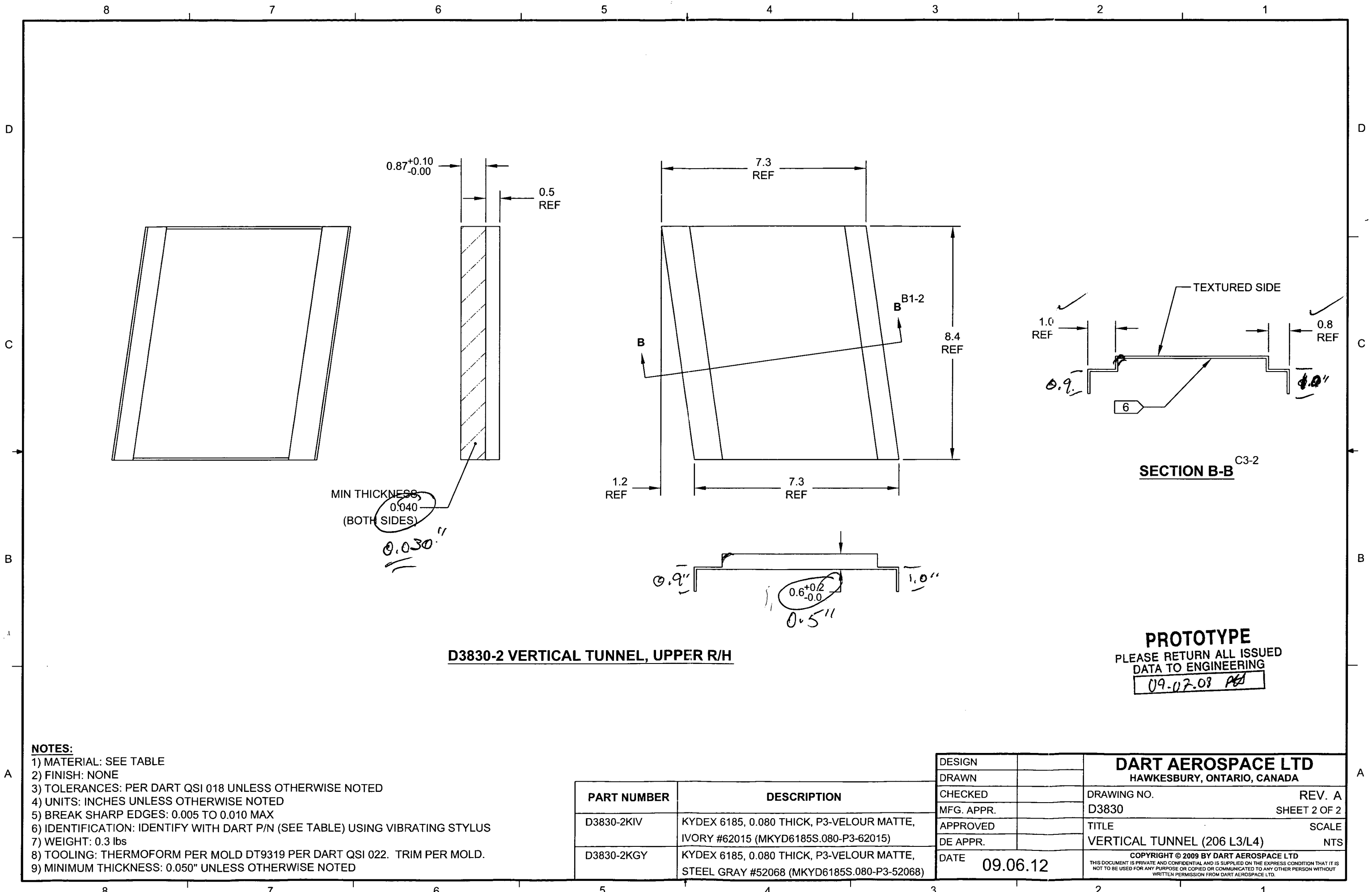
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50"	±.100	0.5281	✓			
0.90"	±.100	0.706"	✓	-		Deviation
1.00"	±.100	0.752"	✓	-		Deviation
0.050"	M.I.W.	0.068"	✓			
0.090"	M.I.W.	0.041	✓			

U-030
U-035
PH
09.0720

Measured by: <u>W. Heger</u>	Date: <u>09/07/15</u>
Audited by: <u>PH</u>	Date: <u>09.07.17</u>
Prototype Approval: <u>PH</u>	Date: <u>09.07.17</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



MIN THICKNESS
0.040
(BOTH SIDES)
0.030"

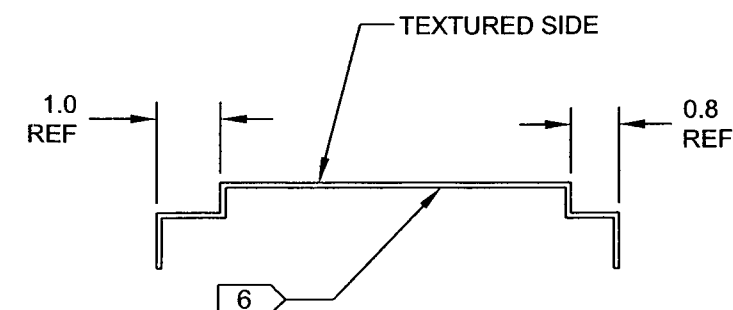
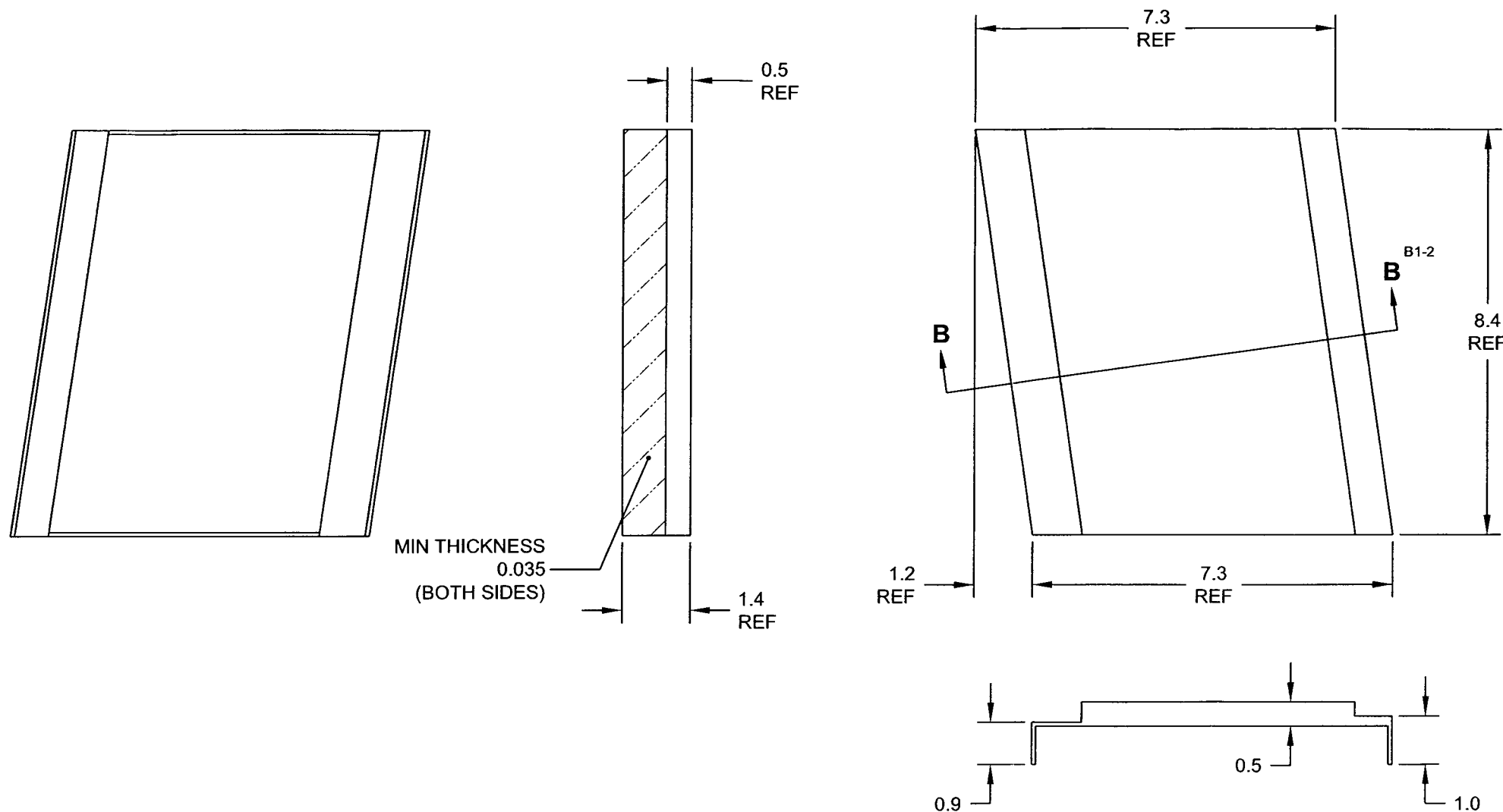
D3830-2 VERTICAL TUNNEL, UPPER R/H

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09-07-08 *PE*

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 0.3 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9319 PER DART QSI 022. TRIM PER MOLD.
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3830-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3830-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3830	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL (206 L3/L4)	NTS
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SECTION B-B C3-2

D3830-2 VERTICAL TUNNEL, UPPER R/H

NOTES:

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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D3830 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		VERTICAL TUNNEL (206 L3/L4) NTS
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